

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014545**Date Inspected:** 30-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bay 9**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 12

No Relevant observations

Bay 9

Gantry Welding

This inspector performed In- Process inspections of production welding of deck panels in Bay 9. Welding was being performed on panel DP3081-001. The weld procedure was found to be WPS-B-T-2342-U1-(U-rib)-5. The welding operators were identified as follows:

Weld 1- 059416

Weld 2- 201788

Weld 3- 203805

Weld 4- 059378

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld 5- 203805

Weld 6- 059378

ZPMC and ABF QC were present during the welding process and identified as Zhang Qiao and Huang Wen Guang respectively. The ZPMC CWI was present during the welding process and identified as Guo Yanfei.

During FCAW root welding process, the welding parameters were verified by this inspector and were as follows:

Head 3, Weld 1- 360 Amps, 31.5 Volts

Head 4, Weld 2- 352 Amps, 31.4 Volts

Head 3, Weld 3- 365 Amps, 30.8 Volts

Head 4, Weld 4- 357 Amps, 30.3 Volts

Head 5, Weld 5- 351 Amps, 31.2 Volts

Head 6, Weld 6- 361 Amps, 30.5 Volts

Travel speed recorded by QC was 536 mm/min

Tack Welding

This QA Inspector observed ZPMC welding personals identified as 059466 and 059472 performing Gas Metal Arc welding (GMAW) tack welding on DP3135-001 (13BW) deck plate to U-rib. ZPMC QC is identified as Zhu Zhong Jie. The welding variables recorded by QC appeared to comply with the WPS-345-B-T-2342 U5b (U-Rib).

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------
